Work Order ID 62899

Tuesday, October 12, 2010 3:40:54 PM

Item ID: D2989-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/22/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 10-10-19 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2989	Rev D

100 0.00

Large Fab

Large Fab

Large Fab

Memo 0.00

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989
A/R ER316 S.S. Rod Batch: M114649

10/10/19 (K)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Quality Control

Memo 0.00

QC 10-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00				1			10-10-20
Quality Control									
		BL 10-10-20							
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	**Memo**	0.00				0			
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M115991.	0.00 BF 10-10-20.				(1)			
Powder Coating	**Memo**	0.00							
	1- Plug holes prior to powder coating 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 1ST COAT: START TIME: 11:55 OVEN TEMPERATURE: 400° FINISH TIME: 12:25. ********** 2nd coat if necessary********** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ N/A								
131 HandFinish	Wing Walk as per dwg QSI005 4.4 Batch M115790	0.00 => MH 10/10/20				1	0		
Hand Finishing	**Memo**	0.00							
	Mask lid prior to spray paint black and wing walk as per dwg A/R Spray paint black batch: M115193 Wing Walk batch no: M115790								

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 62899

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Item ID: D2989-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Start Qty:** 1.00 **Cust Item ID:**

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Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00				1			10/10/21
QC	**Memo**	0.00							
Quality Control									
141	Identify as per dwg & Stock Location: W1062897	0.00							
Packaging	**Memo**	0.00				1			10/10/21
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00					10/10/21		
Quality Control									

10-10-21

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 3:40:59 PM

Work Order ID: 62899

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	14.0000	2	2		10/10/14	
				Location		**Loc Qty**		**Loc Code**					
				WA		14							
					61091	2				1			
					61424	12				1			
D2506 Label Plate		Manufactured	No			100	Each	7.0000	1	1		10/10/14	
				Location		**Loc Qty**		**Loc Code**					
				WA		7							
					61174	2				1			
					61464	5							
D2512-7 Rib		Manufactured	No			100	Each	7.0000	1	1		10/10/14	
				Location		**Loc Qty**		**Loc Code**					
				WA		7							
					60669	3				1			
					62368	4							

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 3:40:59 PM

Work Order ID: 62899

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

D2581	Manufactured	No		100	Each	51.0000	2	2

Mounting Bracket

Location	Loc Qty	Loc Code
WA	51	
60470	31	
61953	20	

D2989-13	Manufactured	No		100	Each	6.0000	2	2

Rib

Location	Loc Qty	Loc Code
WA	6	
61425	6	

D2989-19	Manufactured	No		100	Each	6.0000	2	2

Rib

Location	Loc Qty	Loc Code
WA	6	
61427	6	

D3832-3	Manufactured	No		100	Each	3.0000	1	1

Mesh (Lid)

Location	Loc Qty	Loc Code
WA	3	
61284	3	

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 3:40:59 PM

Work Order ID: 62899

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

✓	D3833-3 Mesh (Lid End)	Manufactured	No		100	Each	13.0000	2	2 SY 10/10/18

Location	Loc Qty	Loc Code
WA	13	
46308	1	
61319	6	
62384	6	

✓	D3836-041 Rib Assembly (Basket Lid, LH)	Manufactured	No		100	Each	3.0000	1	1 SY 10/10/14

Location	Loc Qty	Loc Code
WA	3	
61429	3	

✓	D3836-042 Rib Assembly (Basket Lid, RH)	Manufactured	No		100	Each	3.0000	1	1 SY 10/10/14

Location	Loc Qty	Loc Code
WA	3	
61431	3	

✓	D3852-041 Rib Assembly	Manufactured	No		100	Each	3.0000	1	1 SY 10/10/14

Location	Loc Qty	Loc Code
WA	3	
61433	3	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID: 62899

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010 **Required Date:** 10/22/2010

Start Qty: 1.00 **Required Qty:** 1.00

D3852-042	Manufactured	No		100	Each	3.0000	1	1

Rib Assembly

10/10/14

Location	Loc Qty	Loc Code
WA	3	
61434	3	

1

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

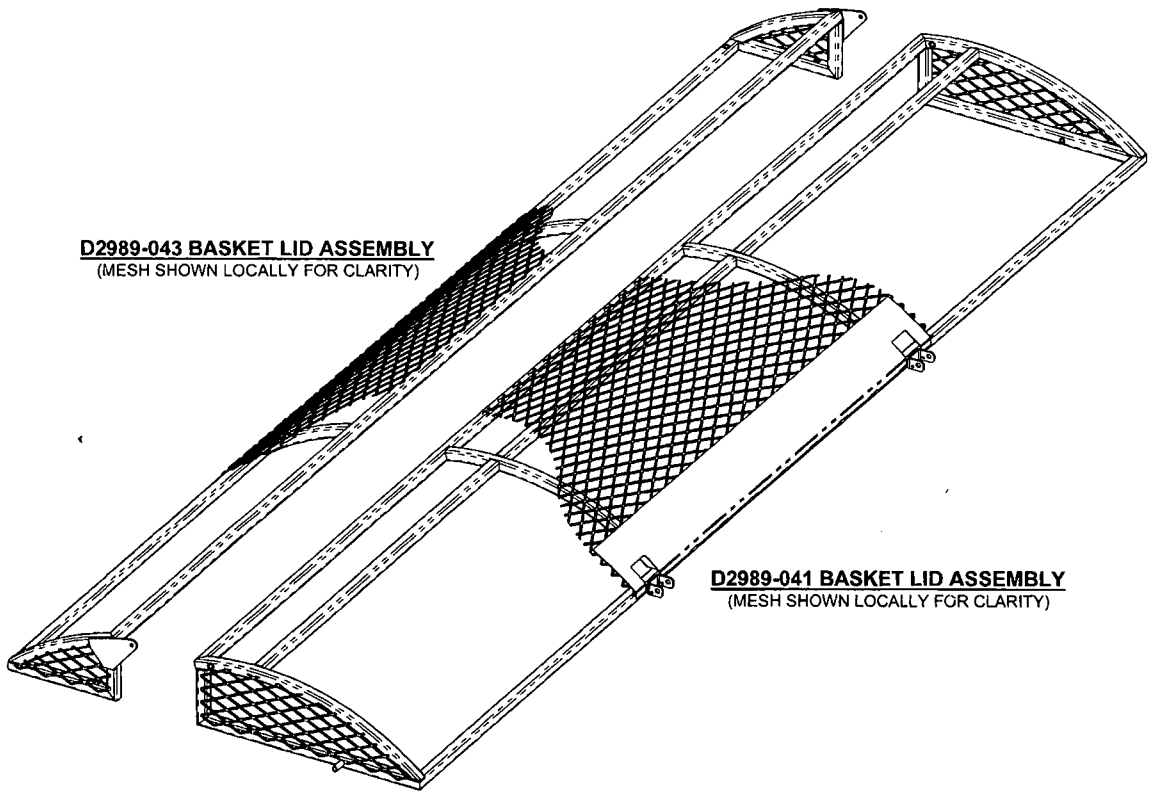
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	**BASKET LID ASSEMBLY**
2		X	D2989-043	**BASKET LID ASSEMBLY**
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED 08/11/18 MB

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

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SUPPLIED FOR
ORDER
NO. 03527
8/10/12

REV.	DESCRIPTION	BY	DATE
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27

DESIGN	DS	**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24		

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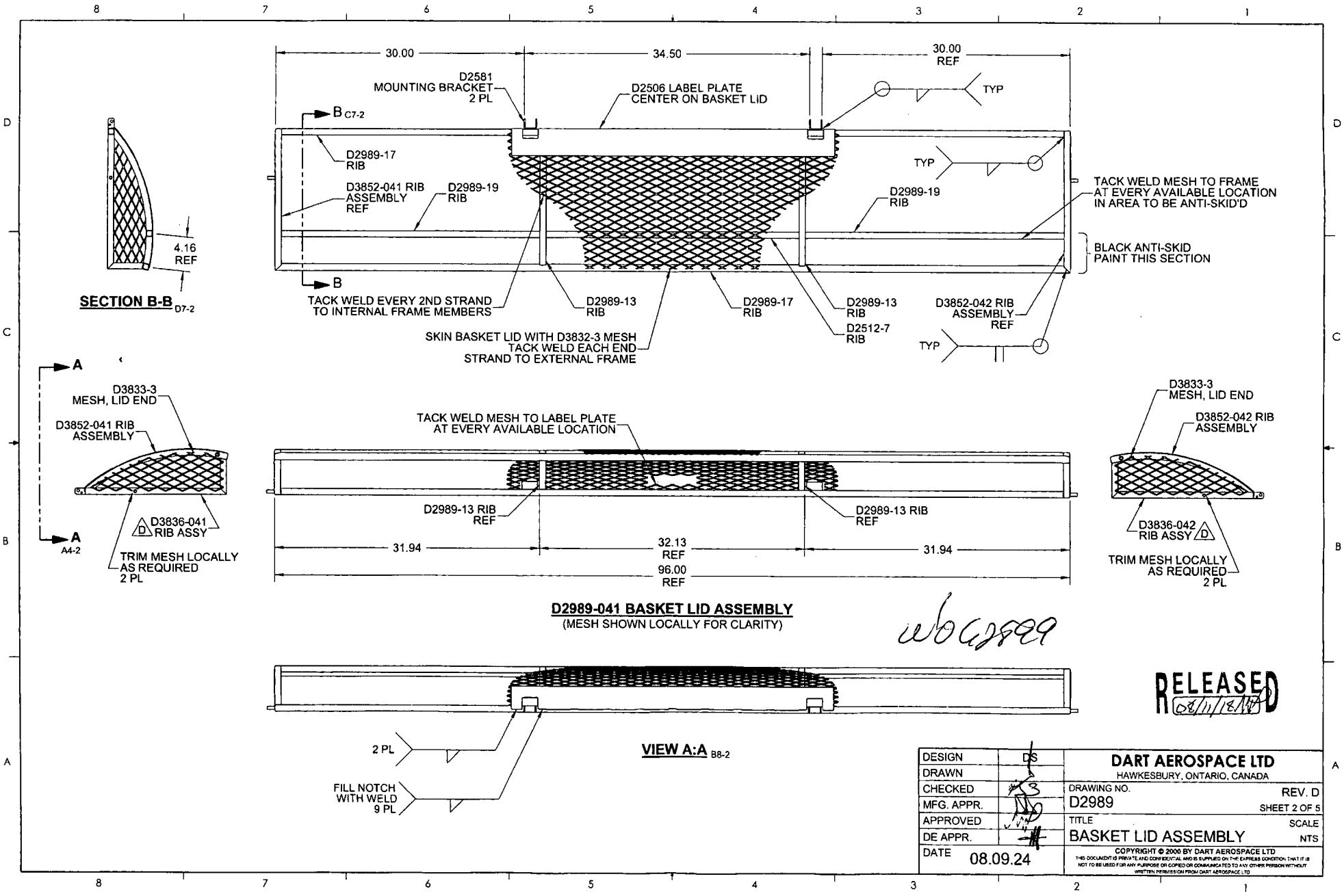
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



wo d2989

RELEASED 08/11/2024

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2989 REV. D
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.09.24	

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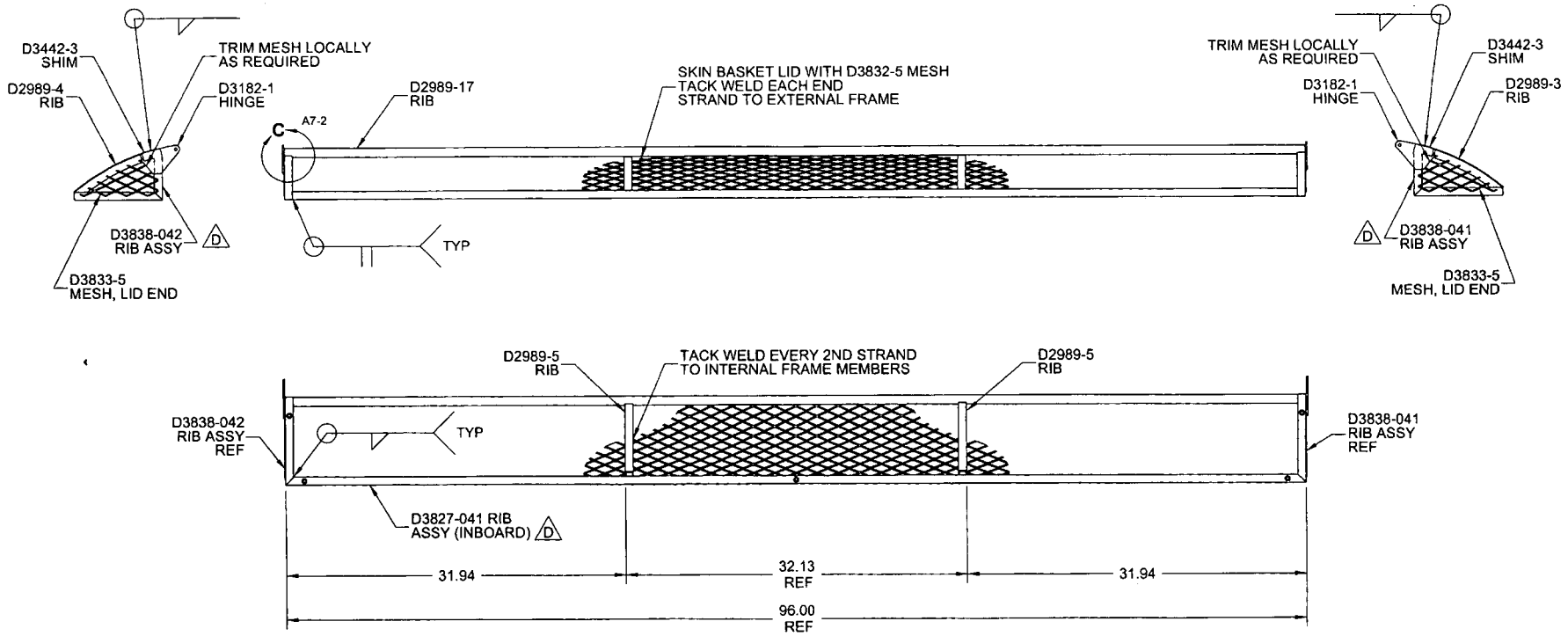
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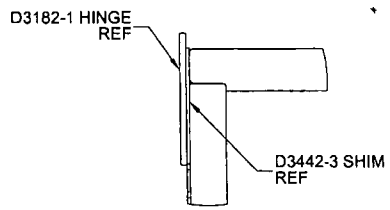
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NOTE: Date & initial all entries



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

WO 42929



DETAIL C D7-2
TYP, SCALE 4X

RELEASED
08/11/18

DESIGN	DS	**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.			
DATE	08.09.24		

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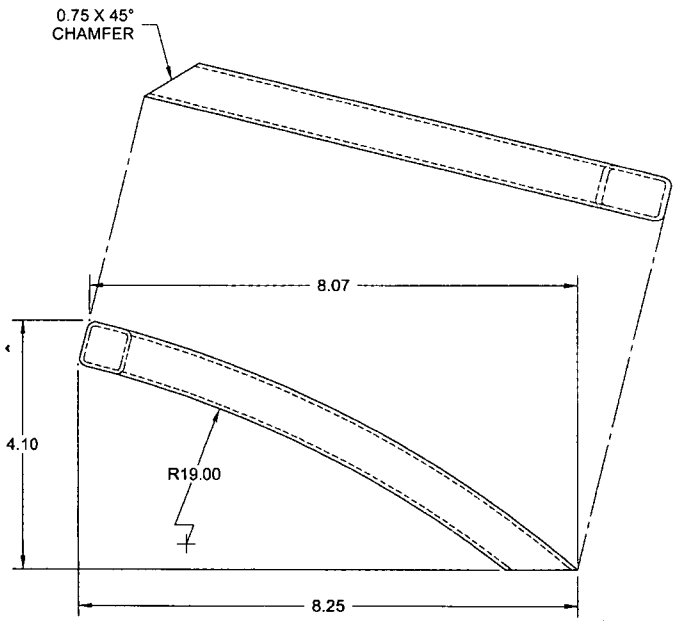
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

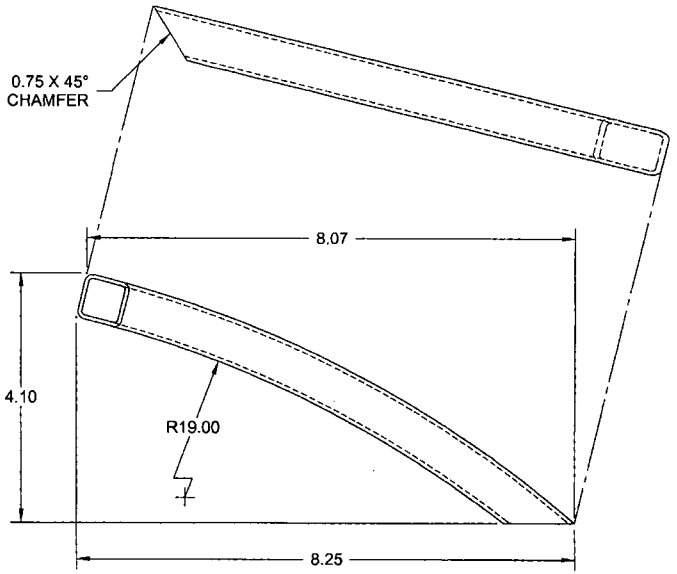
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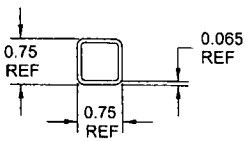
D2989-3 RIB



D2989-4 RIB

w/o 62989

RELEASED 08/11/18 AWD



TYPICAL SECTION VIEW

NOTES:
1) MATERIAL: D3166-3 BASKET HOOP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2989 REV. D
CHECKED		SHEET 4 OF 5
MFG. APPR.		TITLE BASKET LID ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	08.09.24	

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Dart Aerospace Ltd

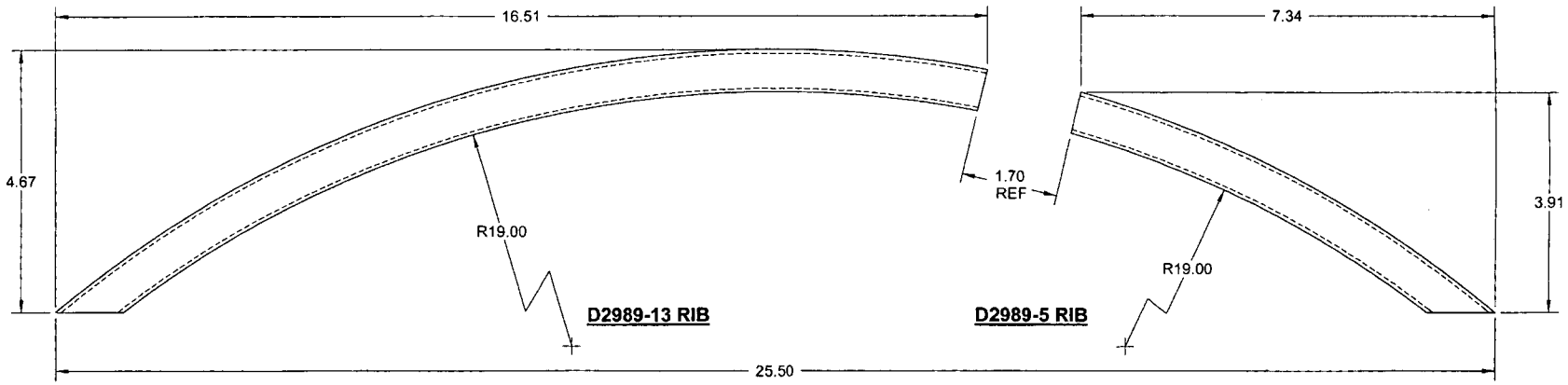
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

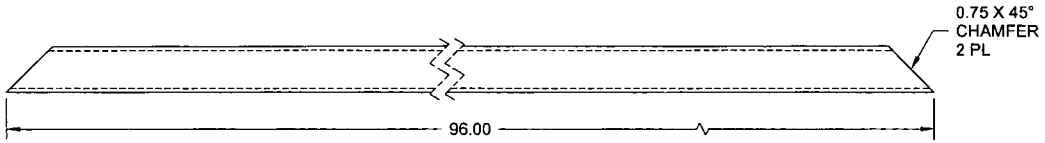
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

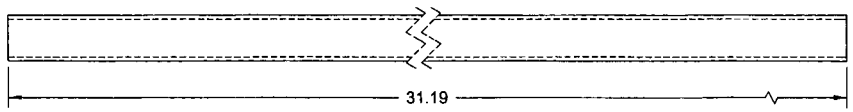
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



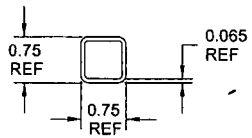


D2989-17 RIB



D2989-19 RIB

wo 62899



TYPICAL SECTION VIEW

RELEASED
08/11/18 MD

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2989 REV. D
CHECKED		SHEET 5 OF 5
MFG. APPR.		TITLE BASKET LID ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	08.09.24	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries